

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018690**Date Inspected:** 24-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

Heat straightening, using gas torch, of PCMK OBG 11EW, north (counterweight) side, longitudinal diaphragm immediately west of panel point 107. QC was identified as ZPMC CWI Liu Hua Jie (QC1). Assisting QC1 at this location and appearing to be monitoring the heat straightening and recording data was ZPMC QC Zhou Peng (QCA1), who was not a CWI. Heat treatment observed by this QA Inspector and recorded by QCA1 appeared to comply with HSR1(B)-9552 as presented to this QA Inspector by QCA1. See photo below of mechanical jack being used to apply pressure as the longitudinal diaphragm was being heat treated. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cai Hai Zhou.

SMAW repair welding of several welds located inside PCMK OBG 11DW/11EW, bottom plate, holdback welds. Welder was identified as 050289. QC was identified as QC1. This QA Inspector observed the welders performing SMAW welding on bottom plate T-rib to bottom plate welds. QC1 informed this QA Inspector that this welding was the result of ZPMC visual testing and QC could not provide weld numbers. Welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as verbally identified by QC1. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Cai Hai Zhou.

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## WELDING INSPECTION REPORT

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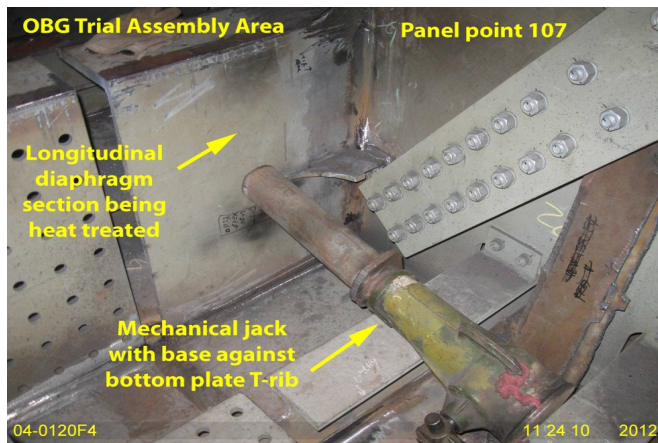
ZPMC personnel match drilling bottom plate T-rib flanges and side plate T-rib flanges - south (bikepath) side, through previously drilled holes in the splice plates into 11DE at the 11CE/11DE transverse joint, using magnetically-held drill presses.

### Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base pedestal at end of the Heavy Dock. All four towers, lift 5 were positioned on top of the respective lift 4. No work was being performed on the Heavy Dock and no floating crane was in the area of the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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